

41.12

Dart Aerospace Ltd.

Date: Tuesday, 3/11/2008 7:53:51 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BELL CRANK
Job Number : 37727	
Estimate Number : 11967	
P.O. Number :	Part Number : D2056
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D2056 REV B2
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B2
Previous Run : 37629	Material :
Written By :	Due Date : 3/29/2008 Qty: 12 Um: Each
Checked & Approved By : <u>JA 080311</u>	
Comment : Est. E 02.04.04 Added Rev.B2 NG	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"
-----	--------------------	--------------------------



Comment: Qty.: 0.2494 f(s)/Unit Total : 2.9925 f(s)  
 6061-T6 Bar 1.25 x 1.25"  
 Material: 6061-T6, 1.250" x 1.250" Batch: M104 554

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW  
 Cut blanks 2.80" long

SA 08/03/15

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per folio D2056  
 Tumble  
 Deburr any rough edges after tumbling

J.L 08/03/19

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/03/19

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

JP 08/03/19

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1  
 Acid etch and Alodine as per QSI 005 4.1

BT 08-03-23 (12)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:53:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BELL CRANK

Job Number: 37727

Part Number: D2056

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M 100700



(12X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m-l

08/03/26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



48



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-26

(X13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5/10

08/3/27 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

Job Completion



m-l

08-03-27

(12)

V

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

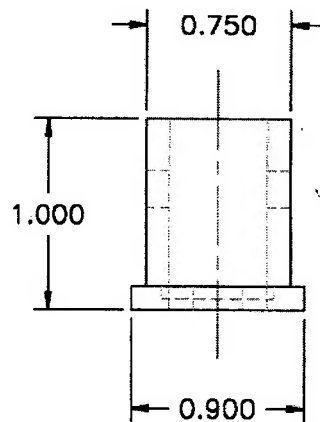
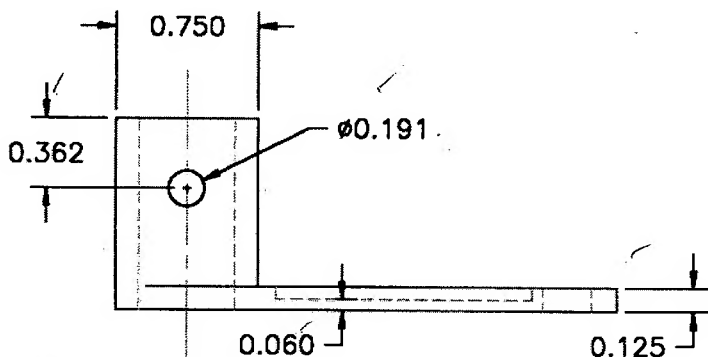
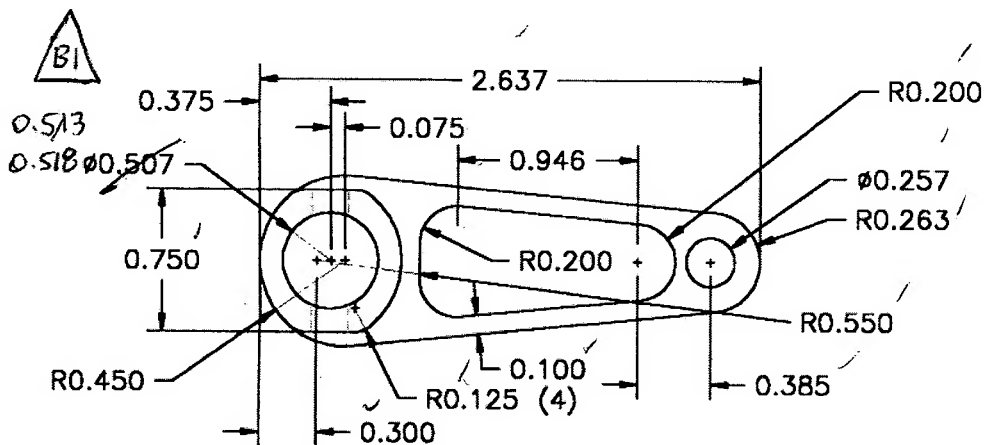
NOTE: Date & initial all entries

**DART**



**RELEASED**  
99.04.28 KAE

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
B WILLIAMS	K HAND		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
<i>W</i>	<i>KAE</i>	D2056	
DATE	TITLE		SCALE
92.03.13	BELL CRANK		1:1
B	95.11.02	RE-DESIGN	
B1	01.06.04	MODIFY HOLE SIZE, ADD FIL OPTION	
B2	01.12.20	ADD NOTE ON TOLERANCES	



**B1** ACID ETCH & ALODINE PER  
DART QSI 005 4.1  
POWDER COAT BLACK STAMPER  
(4.3.5-7) PER DART  
QSI 005 4.3

**B2**

MATERIAL: 6061-T6 (QQ-A-225/8)

FINISH: ANODIZE (BLACK) OR

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37727



17  
17